

Date: Wednesday, 06/09/2006 11:05:20 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GPS BOTTOM MOUNTING
Job Number	: 28423		
Estimate Number	: 12521		
P.O. Number	: N/A	Part Number	: D35303
This Issue	: 06/09/2006 S.O. No. : N/A	Drawing Number	: UNDER REVIEW <i>EC 06-09-05</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: N/A
Previous Run	: N/A	Material	: N/A
Written By	: <i>EC</i>	Due Date	: 13/09/2006 Qty: 2 Um: Each
Checked & Approved By	: _____		
Comment	: Est Rev:A New Issue 06-09-06 EC		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.4865 sf(s)/Unit Total : 0.9729 sf(s)
6061-T6 .040 Sheet
(M6061T6S040)
Batch: *M19380* *MM 06 09 06*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3530
Dwg Rev: *PREL*
Prog Rev: *PREL*

MM 06 09 06

(2)

2-Deburr if necessary

MM

06 09 06

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MM

06 09 06

(2)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EC

06-09-06

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Bend as per Dwg D3530

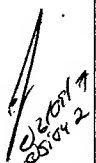
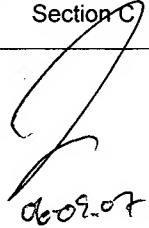
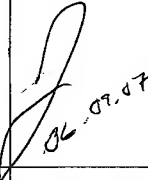
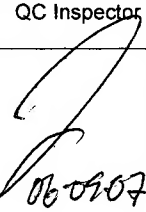
SP

06/09/06

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: ☒ Date: 06/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/07	5	1 piece was scrap when bending R 90.0.		Scrap + destroy review bend. R 90.0	SB 06/09/07			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-09-08

①

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-09-14

①

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 060914

①

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST447*

LB 06/09/14

①

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

RS 06/09/14

①

Job Completion



U 06-09-14

ENG APPROVAL

PART INSPECTED AFTER INSTALLATION
PART OK FOR TESTING ONLY

CB 07.07.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

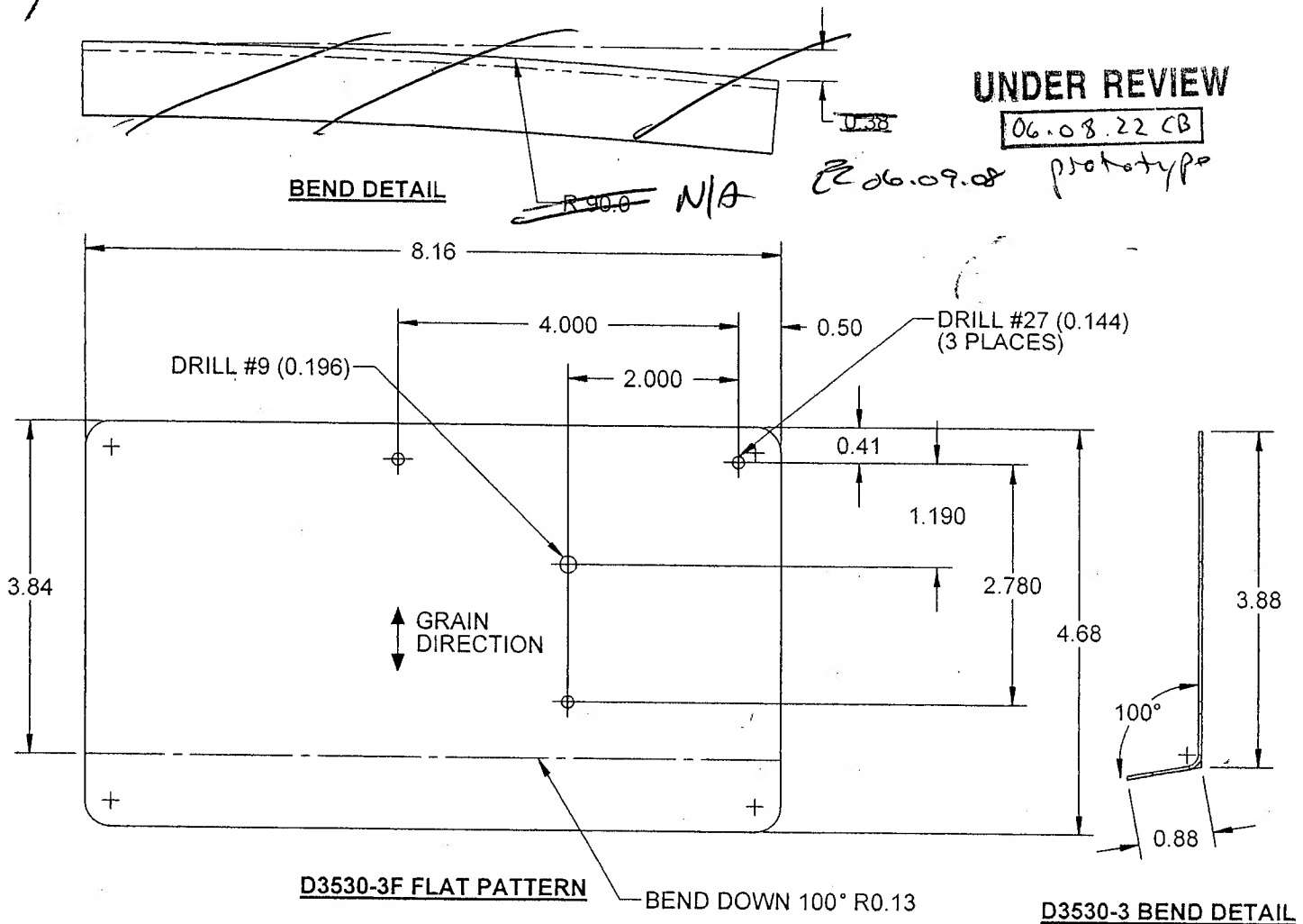
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3530	REV. A SHEET 2 OF 2
DATE 06.06.21		TITLE GPS BOTTOM MOUNTING	SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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